

5/44

DART AEROSPACE LTD	Work Order:	24625
Description: Hinge Bracket	Part Number:	D2857-1
Drawing: D2857 Rev. A1	Qty:	24

RF 03.09.05

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	PD	05.10.21	24
2	METAL	Cut blanks 5.2" Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) Batch M18218	EP	05/11/01	24
3	HAAS	Machine per folio D2857-1	MB	05/11/13	24
4	QC	Inspect Level 2	MB	05/11/13	24
5	METAL	Tumble N/A Deburr any rough edges after tumbling	MB	05/11/13	24
6	METAL	Acid etch and alodine as per QSI 005 4.3	MB	05/11/15	24
7	QC	Inspect Level 7	MB	05/11/16	24
8	FINISHING	Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3	MB	05/11/16	24
9	QC	Inspect Level 3	CL	05/11/16	24
10	STORES	Identify and stock	MB	05/11/16	24
11	EXPEDITING	Close W/O Cost / Part: 23.09 545 05/11/21 22.30	MB	05/11/21	24

Rev	Date	Change	Revised By	Approved
A	99.01.04	New	KS	
B	99.03.25	Added tumble and acid etch	DM	
C	00.06.22	Removed P/O for powder coat	EC	

RELEASED

JUN 26 2009

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/11/21

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	24625
Description: Hinge Bracket		Part Number:	D2857-1
Inspection Dwg: D2857 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.307	—			
0.340	+/-0.010	.343	✓			
1.110	+/-0.005	1.108	✓			
1.790	+/-0.010	1.791	✓			
1.320	+/-0.005	1.322	✓			
2.000	+/-0.010	1.996	✓			
Ø0.171	+0.005/-0.000	.172	✓			
0.147	+/-0.010	.149	✓			
0.376	+/-0.010	.374	✓			
0.126	+/-0.010	.127	✓			
0.063	+/-0.010	.067	✓			
0.166	+0.005/-0.000	.167	✓			
0.911	+/-0.010	.915	✓			
0.600	+/-0.010	.603	✓			
0.125	+/-0.010	.126	✓			
0.150	+/-0.010	.145	✓			

Measured by: BG	Audited by: [Signature]	Prototype Approval:	N/A
Date: 05.11.02	Date: 05/11/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	[Signature]

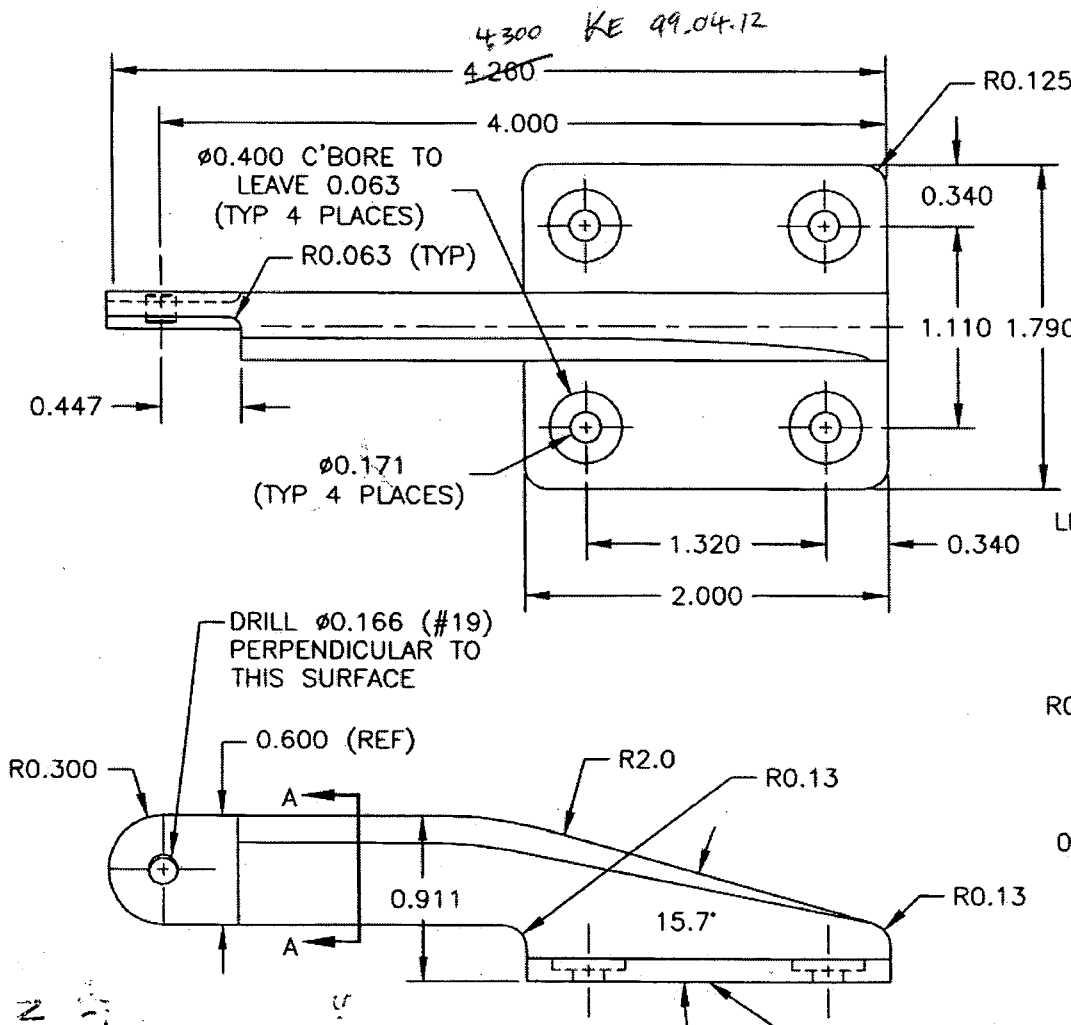
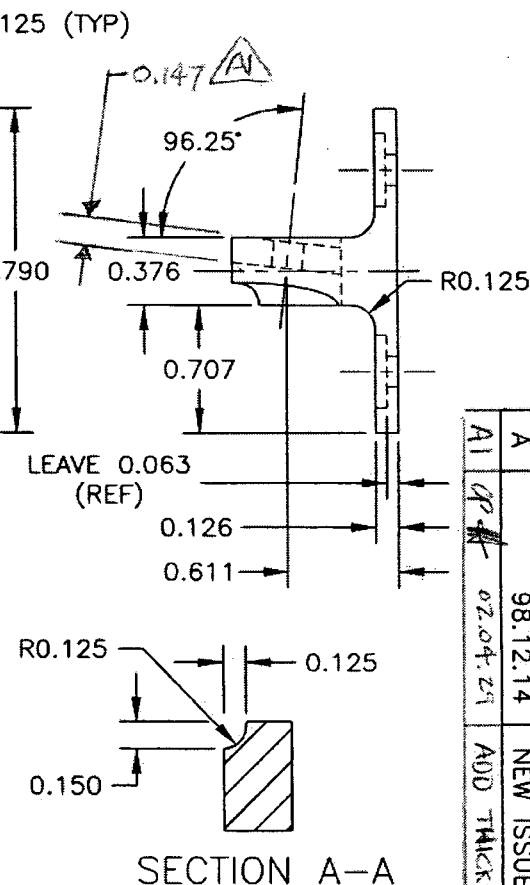
RELEASED

[Signature] 04.02.17



DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	SP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	SP	D2857
DATE	TITLE	REV. A
98.12.14	HINGE BRACKET	SHEET 1 OF 1
SCALE	1:1	
AI	ADD THICKNESS	
A	NEW ISSUE	
98.12.14		
02.04.29		

RELEASED
99.01.06 KE



D2857-1 SHOWN
D2857-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER
NO. 24625
IF USED CO
TO AGENC
HIC T NOTICE
SHEET COPY
DRAFTS
INTERNO

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 20, 2005
04:09 pm

Work Order No : 0024625
Project Name : D2857-1
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D2857-1
Description : Hinge Bracket
Manufactured : Yes
Amount Req'd : 24
Amount Done : 0
Start Date : 10-20-05
Est Finish Date : 11-03-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:41 pm

Work Order No : 0024625
Project Name : D2857-1
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D2857-1
Description : Hinge Bracket
Manufactured : Yes
Amount Req'd : 24
Amount Done : 0
Start Date : 10-20-05
Est Finish Date : 11-03-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	19.50	100.00		
Production Cost :	0.00	466.37	100.00	0.00	466.37
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	14.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	466.37	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	466.37			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-466.37)

MIS 8/13
u
11.13

Date: Monday, 14/11/2005 8:10:45 AM
 User: Alba Panzuto

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HINGE BRACKET	
Job Number :	24625	Part Number :	D28571	
Estimate Number :	10345	Drawing Number :	D2857 REV A1	
P.O. Number :		Project Number :		
This Issue :	14/11/2005	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	A1	
First Issue :	/ /	Type :	MACHINED PARTS	
Previous Run :	24501	Material :		
Written By :			Due Date :	30/11/2005
Checked & Approved By :			Qty:	24
Comment :	Est C 00.06.22 Removed P/O for powder coat EC		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"
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2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks 5.2"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2857-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Tumble
 2-Deburr any rough edges after tumbling

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Acid etch and Alodine as per QSI 005 4.3

Date: Monday, 14/11/2005 8:10:45 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 24625

Part Number: D28571

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

